

Work Order ID 71496

Tuesday, July 05, 2011 8:58:47 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

W 11 07 28
HJ BG 11-7-28

71496

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Check DT8863B on second side of tube and drill pilot holes for detail B
SECOND SIDE

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

DL 11/07/12

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: M115778

BB 11/07/13

12-Grind welds flush as per Dwg D2750

BB 11/07/14

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/07/14

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/07/14

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

BE 11/07/14

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1

BE 11/07/14

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: 117516 exp. date: 12/01/15								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R: Aluminum Rod batch: M15778								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

BB 11/07/14

BB 11/07/14

BG 11/07/18
BE 11/07/18

BB 11/07/18

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Reference:

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Deburr holes

B11/07/18

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Sub 7/19

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 7/19

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Required Date: 7/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 φ M. 11/07/20

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

MU7745.

Memo

0.00

Powder Coating

START TIME: 10:15
OVEN TEMPERATURE: 320°
FINISH TIME: 10:45

1 φ PL 11-7-21.

210 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 φ M. 11/07/20

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

1 0 11/07/27

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: N/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
BATCH: 11/117516
EXP DATE: 15/014-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 11/1141895-Coat all exposed fasteners with "LPS Procyon"
batch: 11/114586

1 0 11/07/27

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject-
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/7/28 07 28 (1)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/28

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11/7/28 07 28 (1)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/7/28 (1)

11/7/29

11-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, July 05, 2011 8:58:41 AM

Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 10.09.25 Rearranged procedure steps (KJ)
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as per
 IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	622.0000	38	38			
---------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Insert * ALS4-1032-225

=> 1111524 (x18) 1107127

Location Loc Qty Loc Code

ST282 622
 ALS4-1032-225 => 110768
 117717 409

x20

AN3C5A		Purchased	No			230	Each	1,381.000	34	34			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Bolt

1107127

Location Loc Qty Loc Code

FP-A 7
 115835 7
 ST350 1374
 116419 28
 116549 54
 117343 500
 117764 300
 117872 492

x34

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Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

240.0000

4

4



BOLT

u

1107127

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

239

111982

2

116419

23

116549

2

116704

12

117619

50

117688

100

117872

50

x4

AN6C44A

Purchased

No

230

Each

85.0000

4

4



BOLT

u

1107127

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

83

117763

31

117950

50

118112

2

x4

Tuesday, July 05, 2011 8:58:42 AM

Shop Packet Print

Page 2

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

83.0000

1

1



BOLT



1107127

Location

Loc Qty

Loc Code

FP

40

117511

40

x1

FP-A

8

115960

1

116874

7

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38



washer

1118306



(x38) 1107127

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER

NAS1149C0832R

1114915



(x1) 1107127

D2745

Manufactured

No

230

Each

276.0000

8

8



Bushing



1107127

Location

Loc Qty

Loc Code

FP-A

276

68248

41

69529

155

69816

80

x8

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Shop Packet Print

Page 3

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Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No

230

Each

16.0000

1

1



Blade Fitting Assembly, RH



11/07/27

Location

Loc Qty

Loc Code

FP008

16

62003

2

65099

3

68109

11

D3492-1 Manufactured No

230

Each

132.0000

8

8



Plug



11/07/27

Location

Loc Qty

Loc Code

FP

132

69531

8

69819

52

70689

72

D3492-3 Manufactured No

230

Each

124.0000

8

8



Plug



11/07/27

Location

Loc Qty

Loc Code

FP

124

69822

44

70692

80

D3535-25 Manufactured No

230

Each

36.0000

1

1



Wearshoe



11/07/27

Location

Loc Qty

Loc Code

FP018

36

62233

1

69284

10

69743

25

11/07/27

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

37.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP012

37

68351

11

70780

26

X1

D3537-1

Manufactured No

230

Each

13.0000

3

3



Wearpad

Location

Loc Qty

Loc Code

FP017

13

69278

6

69817

7

1370972

X3

D3631-1

Manufactured No

230

Each

387.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST072

387

68062

387

X8

D3672-1

Manufactured No

230

Each

1,122.000

8

8



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1096

64177

596

66821

500

ST077

26

52505

26

ul 11/07/27

ul 11/07/27

ul 11/07/27

ul 11/07/27 PTO ->

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Page 5

W/O: 71496		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/07/24	230	Replace a Assemble NAS1515H3K / M113362 Permanent change!! (x4)	JE	11/07/24 11/07/28	x4	N/A	S 11/07/28	

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

2.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP017

2

62239

2

B69744

Y1

D3793-1

Manufactured No

230

Each

14.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

69285

14

X1

D3793-3

Manufactured No

230

Each

14.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

68356

6

69283

8

V1

D3794-1

Manufactured No

230

Each

36.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP010

36

68355

12

70779

24

X1

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1



Gasket



Handwritten: 11/07/27

Location

Loc Qty

Loc Code

FP010

17

68357

17

Handwritten: V1

FP018

12

70812

12

MS21043-6

Purchased

No

230

Each

445.0000

4

4



NUT



Handwritten: 11/07/27

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

425

112314

415

117887

10

Handwritten: X4

MS21083C8

Purchased

No

230

Each

97.0000

1

1



NUT



Handwritten: 11/07/27

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

117677

21

Handwritten: X1

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

198.0000

8

8



O-RING



jd 11/07/20

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

FP-A

102

110915

91

115589

11

x8

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING



jd 11/07/27

Location

Loc Qty

Loc Code

FP

171

117291

31

117887

140

FP-A

5

116582

5

x8

AN8C21A

Purchased

No

250

Each

101.0000

2



BOLT



11/17/28

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

117562

26

118045

50

2

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD816



1/2" washer, Alum

Purchased No 250 Each 1.0000

2 2



MAS/149008632

M1180788

Location

Loc Qty

Loc Code

FP-A

1

106043

1

Manufactured No 250 Each 39.0000



D2741



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

39

63589

9

69133

30

Manufactured No 250 Each 83.0000



D3493-1



Washer

Location

Loc Qty

Loc Code

ST062

83

68253

23

70697

60

Manufactured No 250 Each 49.0000



D3532-1



Spacer

Location

Loc Qty

Loc Code

ST065

49

66949

9

69895

40

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

97.0000

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

117677

21

D2600-3-BENT

Manufactured

No

110

Each

18.0000

Extrusion Bent

Location

Loc Qty

Loc Code

LG

18

66875

8

68137

1

70142

9

D2744

Manufactured

No

110

Each

5.0000

Cap

Location

Loc Qty

Loc Code

LG002

5

62715

1

65086

4

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

5.0000

1



350 I Beam



1

BB 11/07/14

Location

Loc Qty

Loc Code

LG

5

69886

5

D2743

Manufactured No

160

Each

163.0000

8



Crossbolt Spacer



8

BE 11/02/18

Location

Loc Qty

Loc Code

LG

105

69818

105

LG001

58

67766

4

68251

54

D3490-3

Manufactured No

160

Each

77.0000

4



Cross Bolt Spacer



4

BE 11/07/18

Location

Loc Qty

Loc Code

LG

77

68952

18

70768

59

4

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 71496

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

97.0000

4

4



Cross Bolt Spacer



BB 7/18

Location

Loc Qty

Loc Code

LG

95

67773

5

69510

30

69823

60

LG001

2

62450

2

4

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

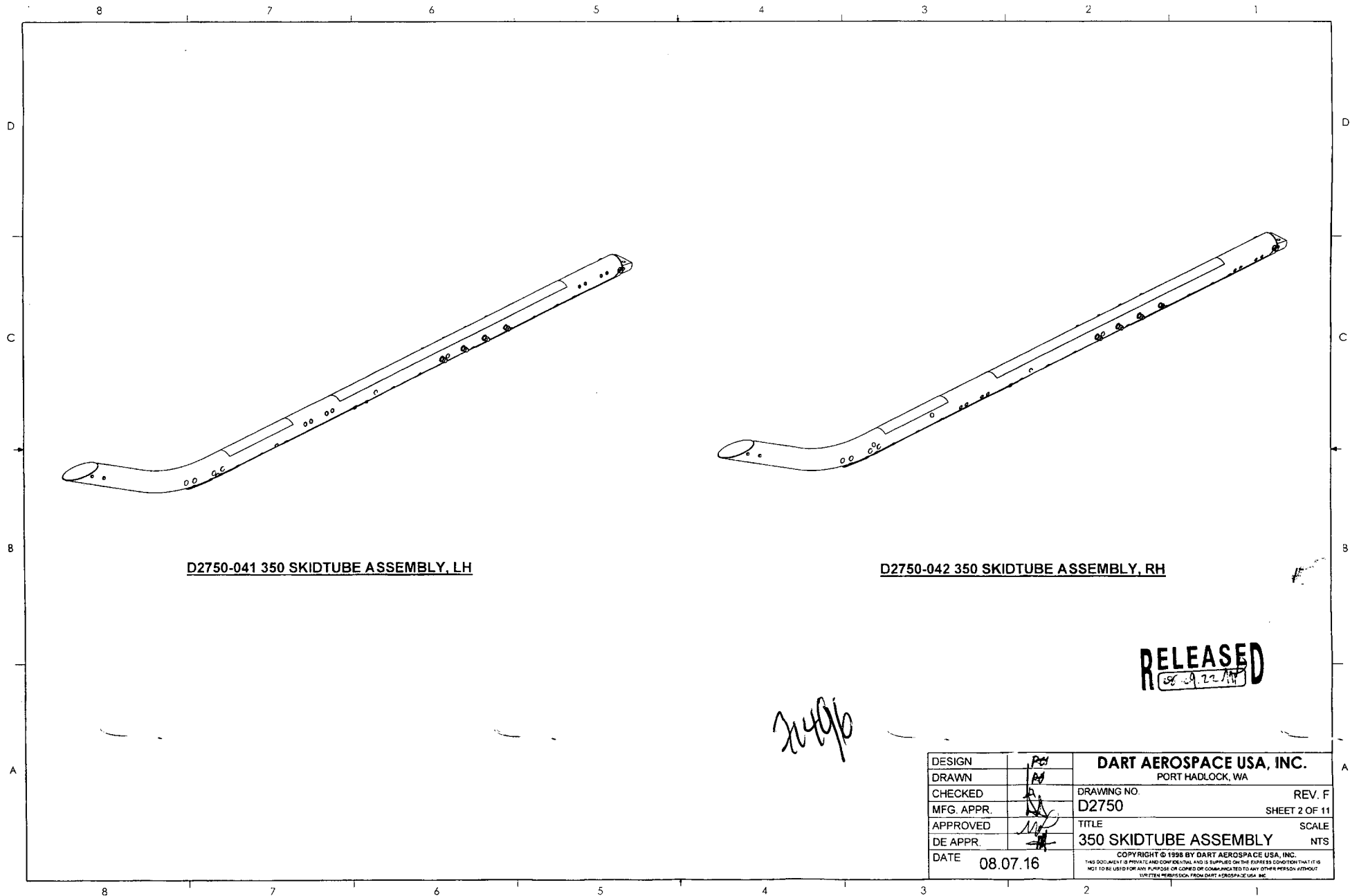
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-046	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
68-09-22-14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	RE	PORT HADLOCK, VA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-09-22-14

2496

DESIGN	PCY	DART AEROSPACE USA, INC.	
DRAWN	AD	PORT HADLOCK, WA	
CHECKED	AD	DRAWING NO.	REV. F
MFG. APPR.	AD	D2750	SHEET 2 OF 11
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

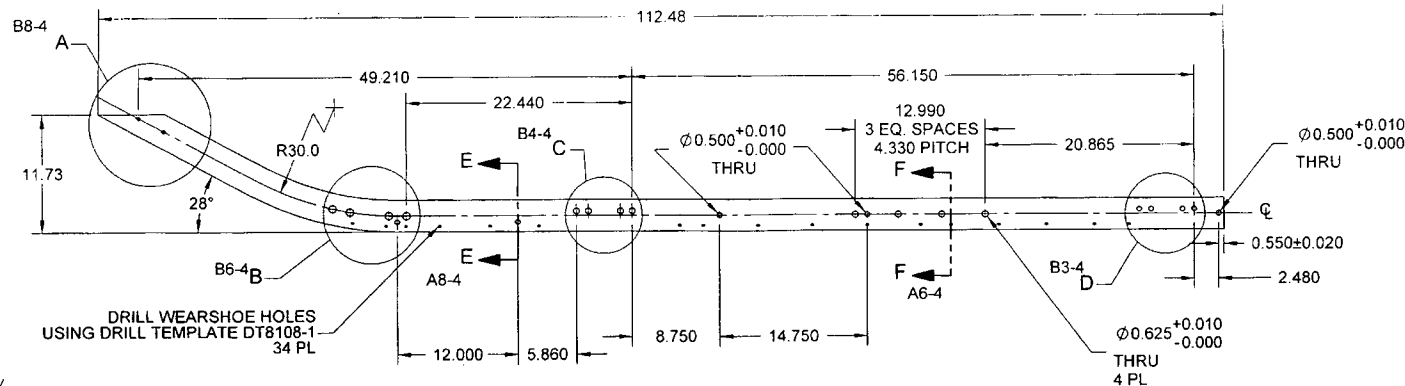
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

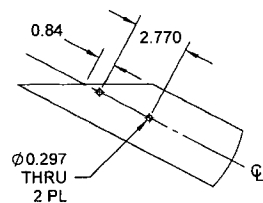
7496

RELEASED
68-09-22/100

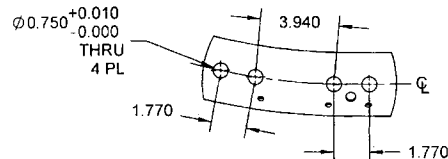
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



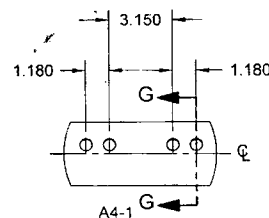
D2750-1 LH SKIDTUBE



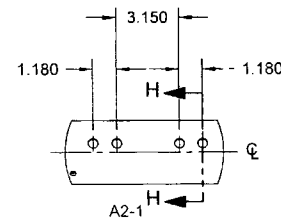
DETAIL A
SCALE 2X



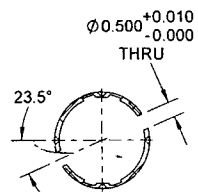
DETAIL B
SCALE 2X



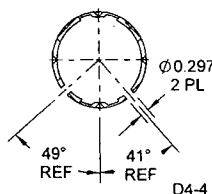
DETAIL C
SCALE 2X



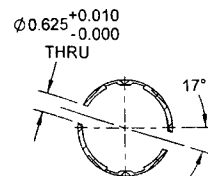
DETAIL D
SCALE 2X



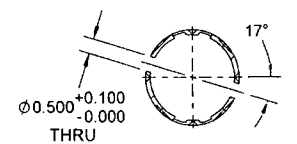
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

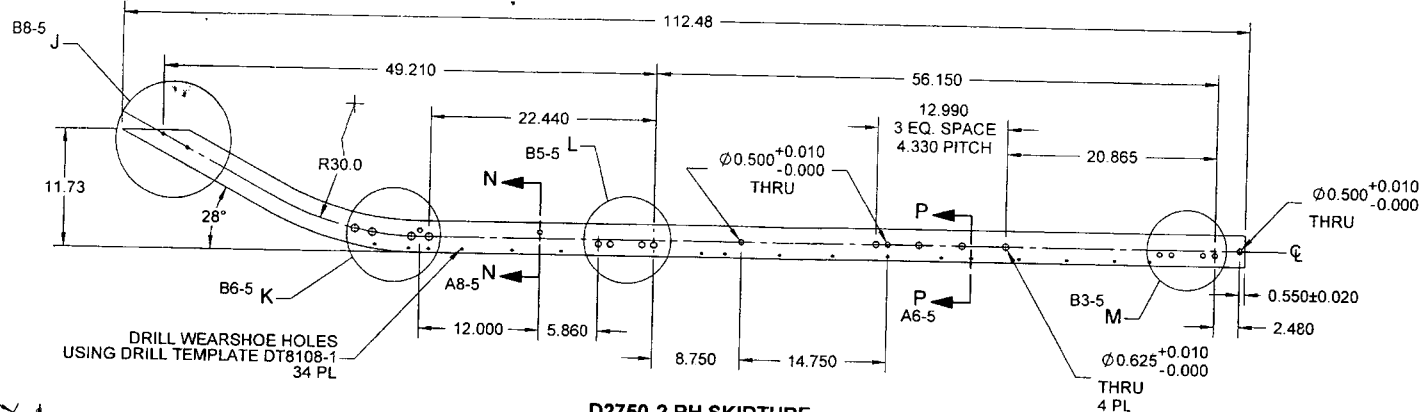


SECTION H-H
SCALE 3X, 4 PL

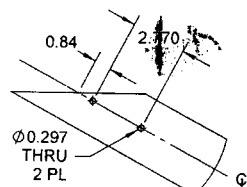
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DESIGN	PA	DART AEROSPACE USA, INC.
DRAWN	PA	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. F
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

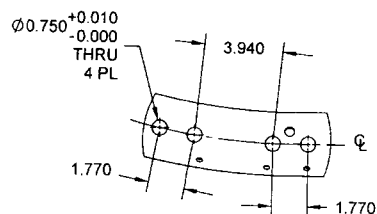
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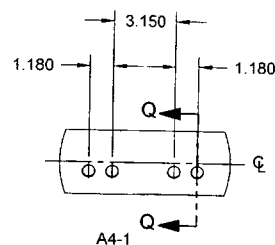
D2750-2 RH SKIDTUBE



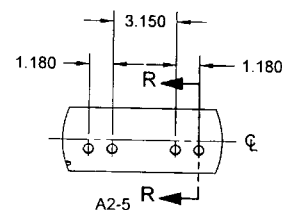
DETAIL J
SCALE 2X



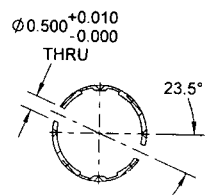
DETAIL K
SCALE 2X



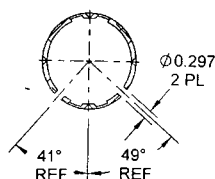
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SCALE 2X



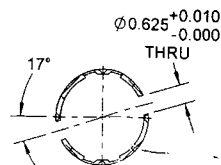
DETAIL M
SCALE 2X



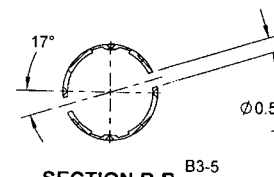
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

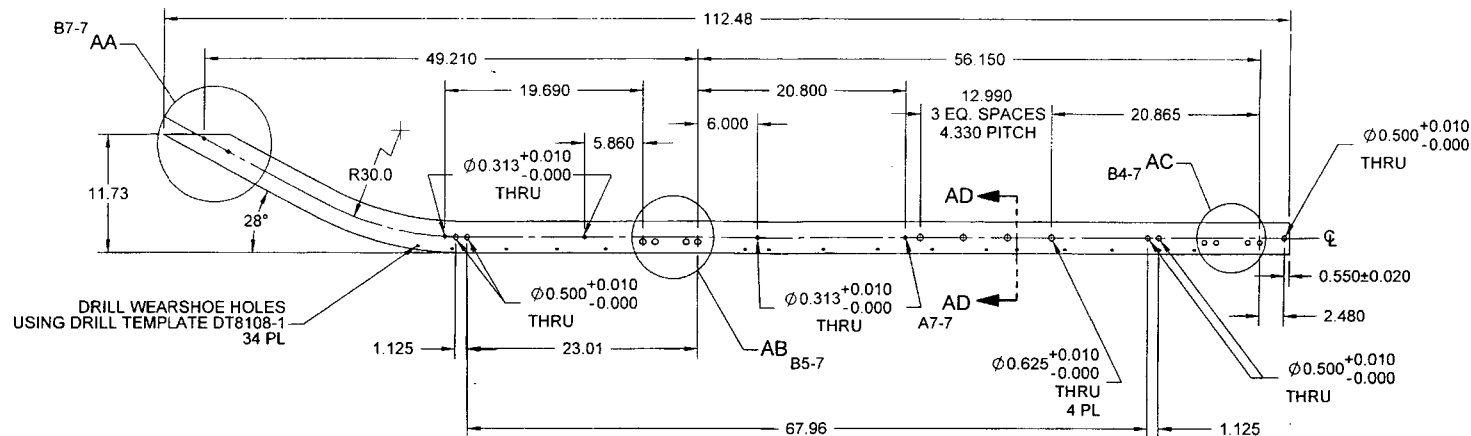
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DRAWN	REV
CHECKED	REV
MFG. APPR.	REV
APPROVED	REV
DE APPR.	REV
DATE	08.07.16

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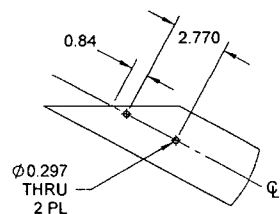
DRAWING NO. **D2750** REV. F
SHEET 5 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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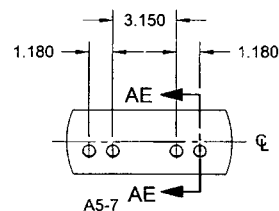
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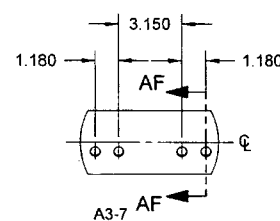
D2750-4 RH SKIDTUBE



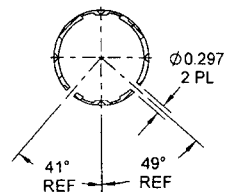
DETAIL AA
SCALE 2X



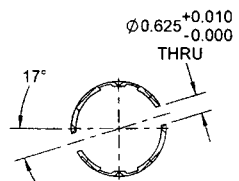
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SCALE 2X



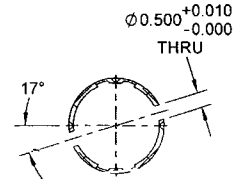
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



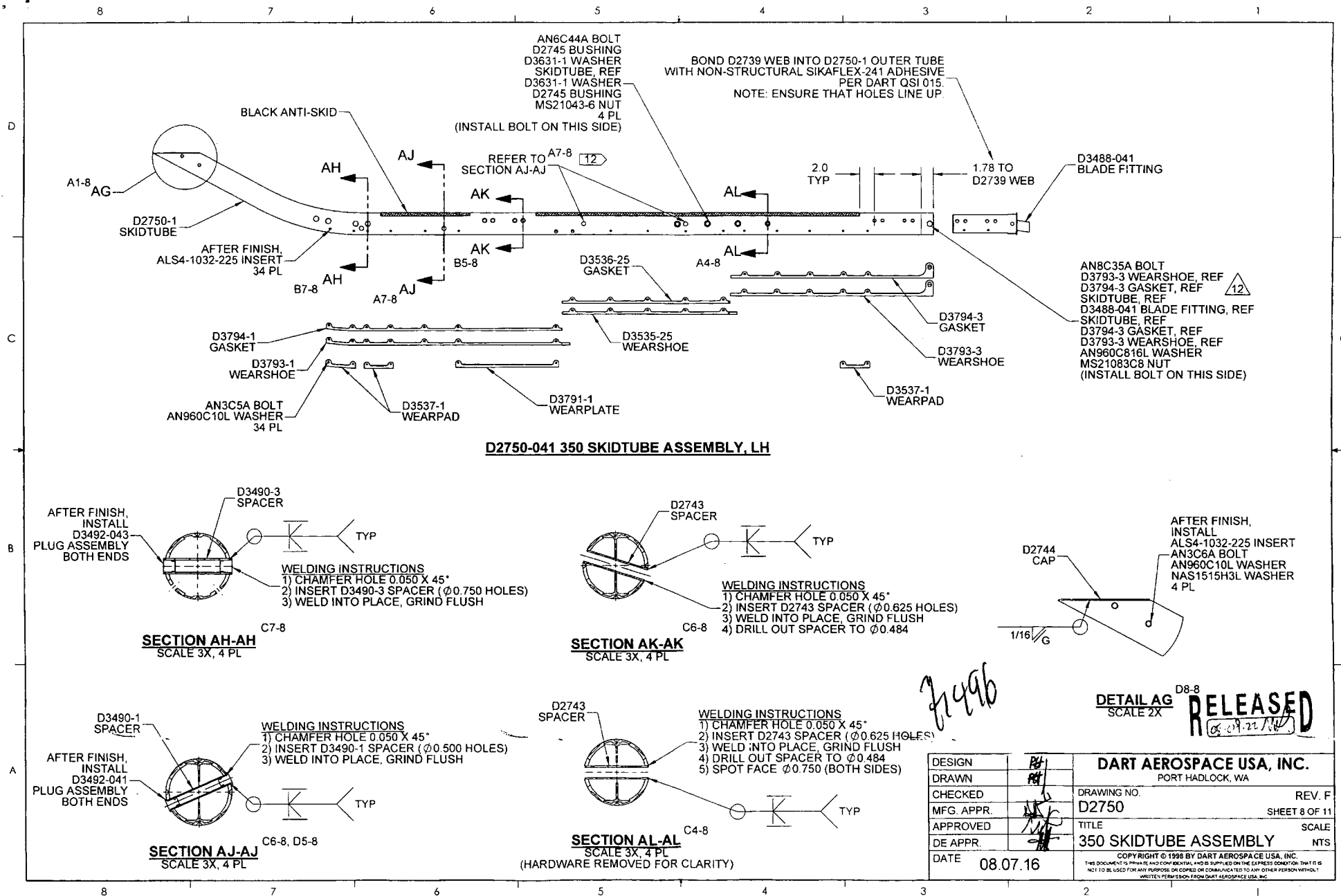
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DRAWN	PA	PORT HADLOCK, WA	
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MFG. APPR.	MP	D2750	SHEET 7 OF 11
APPROVED	MP	TITLE	SCALE
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08-09-22-118



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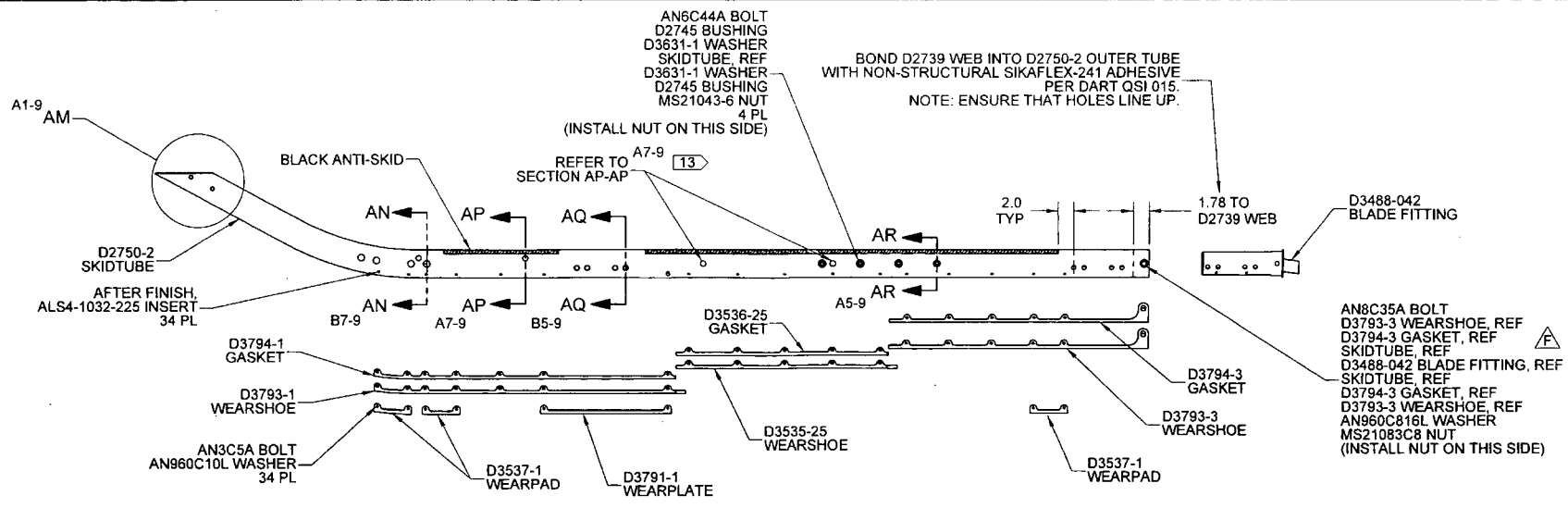
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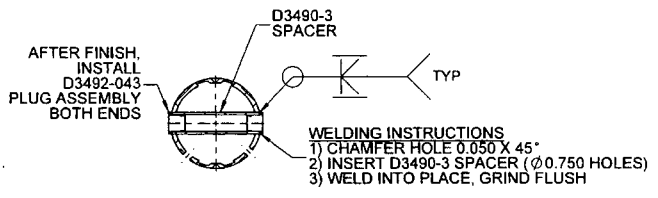
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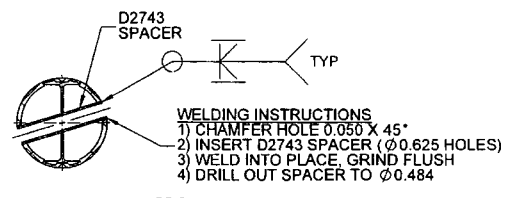
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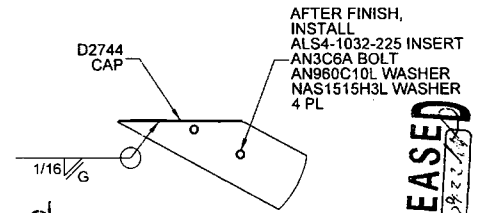
D2750-042 350 SKIDTUBE ASSEMBLY, RH



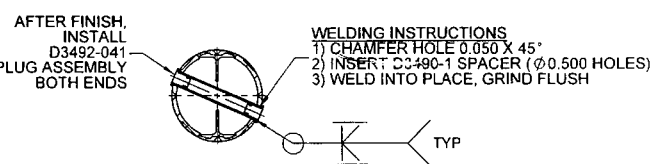
SECTION AN-AN
SCALE 3X, 4 PL



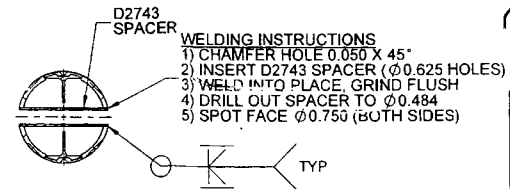
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



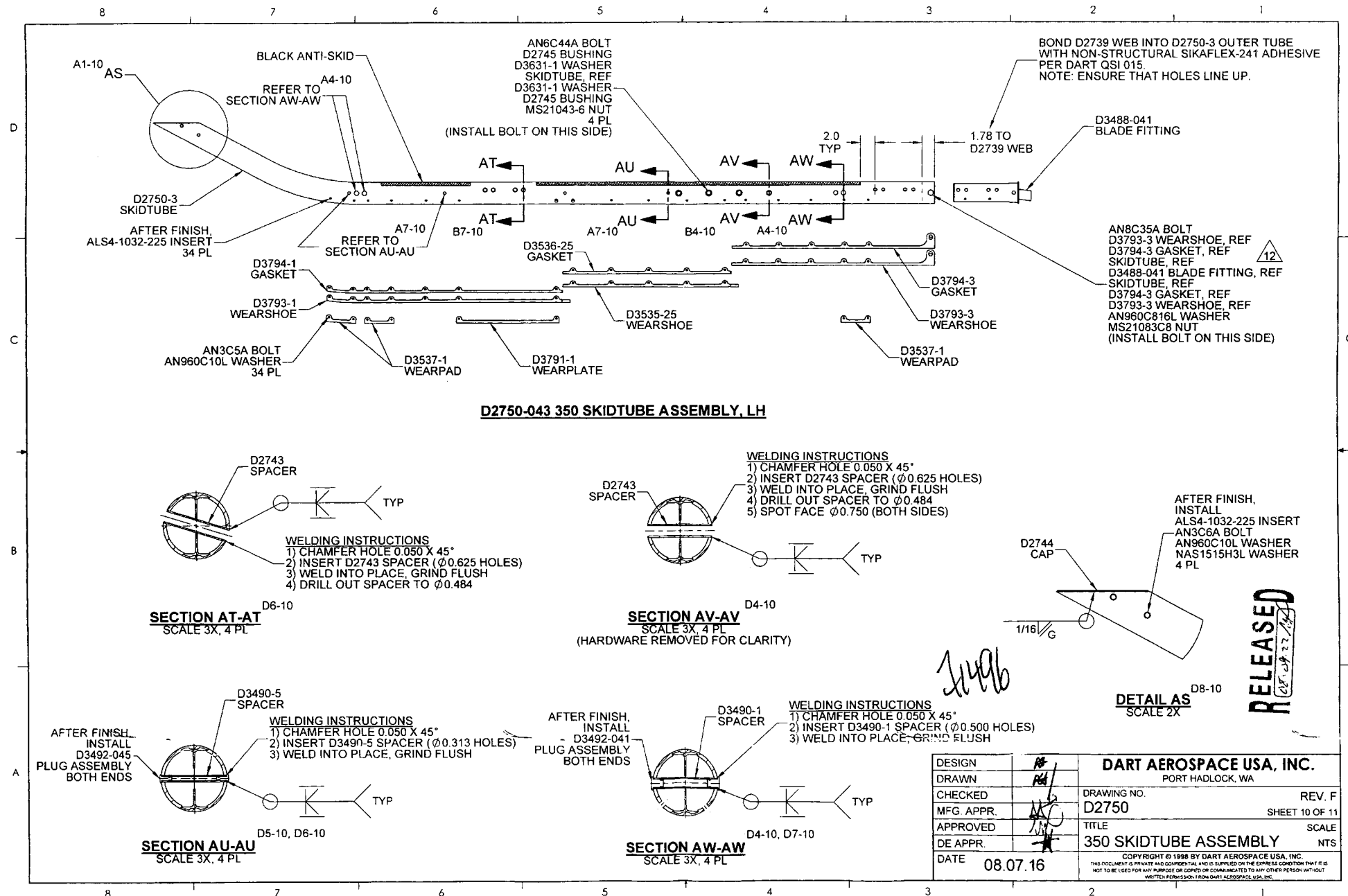
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

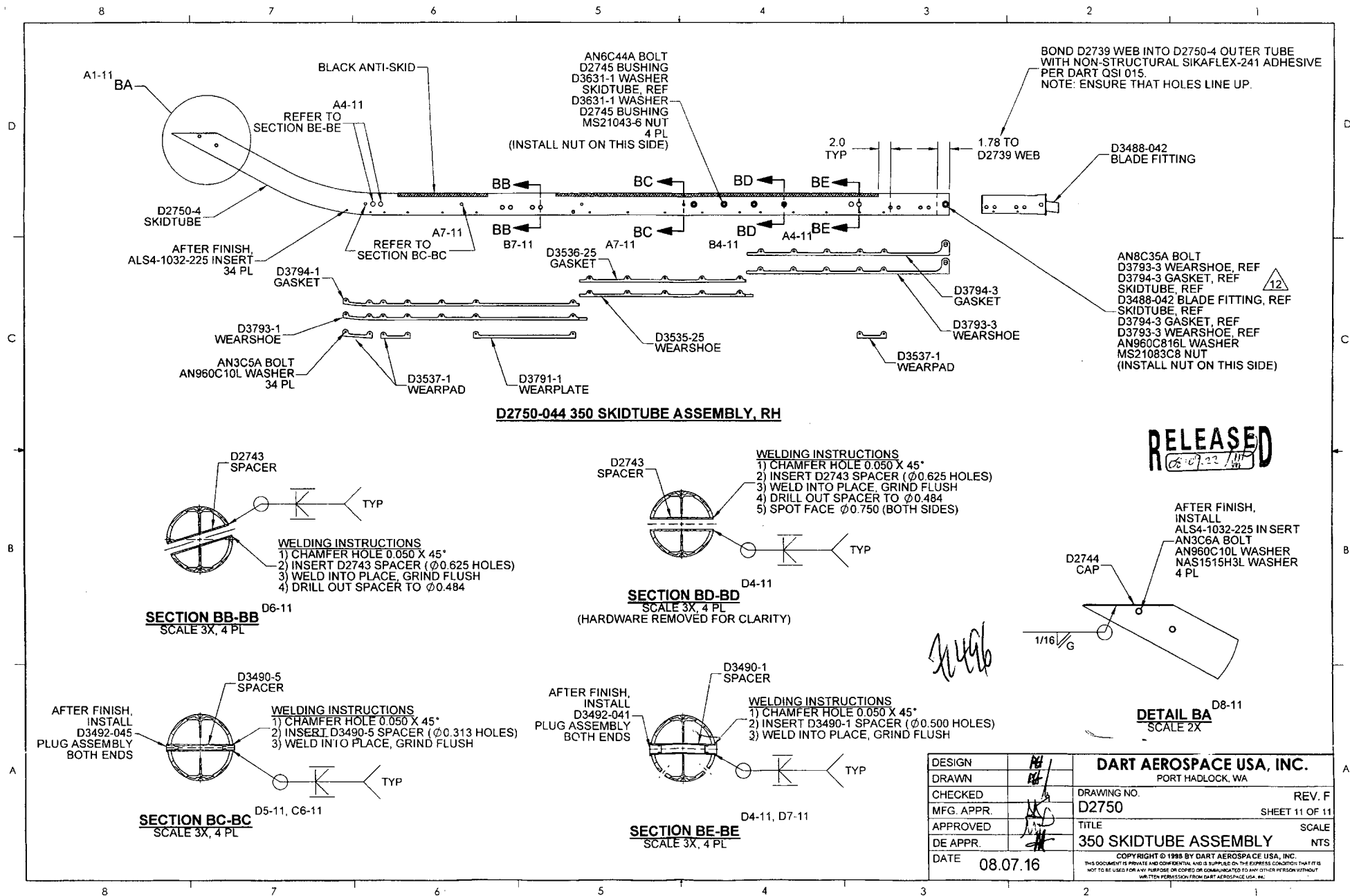
J496

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08-09-2017

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CHECKED	PA	DRAWING NO. D2750
MFG. APPR.	PA	REV. F
APPROVED	PA	SHEET 9 OF 11
DE APPR.	PA	TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS

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NO. 260

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B.69707
Part number: J.350 - 636 - 011
Description: 350
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Dunn Date of Test Coupon 11-07-08
Welder Barclay Elliott Date of Test Coupon 11-07-08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

5.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT (REPLACES AN8-35A)
*6A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
*6B	2	2	2	2		NAS1515H8L	WASHER
*7	1	1	1	1		MS21083C8	NUT (REPLACES MS21083N8)
*8	1		1			D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
*8		1		1		D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT (REPLACES AN8-16A)
11A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
11B	2	2	2	2		D3672-13	WASHER
12	2	2	2	2		MS21083C8	NUT (REPLACES MS21083N8)
*13	4	4	4	4		ALS4-1032-225	INSERT
*14	4	4	4	4		AN6C44A	BOLT (REPLACES AN6-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A	BOLT (REPLACES AN3-6A)

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
*20A	4	4	4	4		AN960C10L	WASHER (REPLACES AN960JD10)
*20B	4	4	4	4		NAS1515H3L	WASHER (REPLACES AN960JD10)
*22	5	5	5	5	5	D3537-1	WEARPAD (REPLACES D2648-3)
*23A	1	1	1	1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
*23B	1	1	1	1	1	D3536-13	GASKET
*24A	1	1	1	1	1	D3535-25	WEARSHOE (REPLACES D2746)
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3535-35	WEARSHOE (REPLACES D2656-35)
*25B	1	1	1	1	1	D3536-35	GASKET
*26A	38	38	38	38	38	AN3C5A	BOLT (REPLACES AN3-5A)
*26B	4	4	4	4	4	AN3C7A	BOLT (REPLACES AN3-7A)
*27	42	42	42	42	42	AN960C10L	WASHER (REPLACES AN960JD10)
*28	38	38	38	38		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

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Revision: I

Date: 10.10.25